

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-708 REV. A AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-708 REV. 1 AND EARLIER  
REF CANADIAN STC: SH99-11  
REF FAA STC: SR00953NY, SR01395NY  
REF EASA STC: 10029207

## 1.0 PURPOSE:

The purpose of this Dart Service Instruction is to allow customers with D205-708-011 and D204-708-013 Adjustable Engine Mounts at CHG 001 or later to replace the MS20613-6C Rivets with HL32PB8-8 Hi-Lok Pins and HL86-8 Hi-Lok Collars.

## 2.0 PROCEDURE:

**NOTE:** The drill, step reamer and piloted drill required to carry out DSI 9703 can be procured from Dart Aerospace.

- 1) Carefully drill out qty (1) existing MS20613-6C Rivet on the adjustable engine mounts using a  $\varnothing 0.191$  (#11) drill.
- 2) Remove all excess sealant from the hole. Clear the hole with P/N 08-550 Drill Bit.
- 3) Enlarge the hole using Piloted Drill P/N 13-420 and ream to  $\varnothing 0.248$  using Step Reamer P/N 44-300.
- 4) If any sharp edges were created when removing the rivet or reaming, deburr as required. Touch up exposed metal with primer in accordance with MIL-P-85582 or MIL-P-23377.
- 5) Select the appropriate length of HI-LOK fasteners, with reference to Table 1 of this service instruction and IIN-D205-708 Figure 2. Install HL32PB8 HI-LOK Pin and HL86-8 Hi-Lok Collar in place of the MS20613-6 rivet wet with Hysol Adhesive EA934. Ensure HI-LOK collars do not interfere with any engine/flight controls.
- 6) Remove all excess adhesive from the adjustable engine mount tube assemblies. Allow the adhesive to fully cure per manufacturer's recommendations prior to use.
- 7) Repeat steps 1 thru 6 until all rivets have been replaced with HI-LOK fasteners. It is critical to only replace one rivet at a time.
- 8) Make an entry in the aircraft log book stating that the replacement engine mounts have been reworked in accordance with DSI 9703 Rev. A.



## 3.0 WEIGHT AND BALANCE:

There is negligible weight and balance change associated with this modification.

RIVET	REPLACEMENT HI-LOK PIN
MS20613-6C12	HL32PB8-8
MS20613-6C16	HL32PB8-12
MS20613-6C18	HL32PB8-14
MS20613-6C19	HL32PB8-14

**TABLE 1**  
HI-LOK Selection Guide

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	14.08.13
CERT. NO.:	SH99-11
ISSUE NO.:	5

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REV.	DESCRIPTION	BY	DATE
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DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9703	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HARDWARE SUBSTITUTION	NTS
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